

5pl.2
Work Order ID 68881 -1

Monday, April 25, 2011 8:38:34 AM



Page 1

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stub Cover

Start Date: 4/25/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3494

Rev D

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: D

2-Deburr if necessary

B 11-4-25

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-4-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/16/12

74

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

50 11/04/28

14

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/17/12

74

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

144



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: M114705

0.00

Memo

0.00

1- WELD
2- GRIND AS PER DWGEL 11-5-3 (x2)

146



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Sulorloz

147



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulorloz(x2)

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Revision ID:

Stop



Item Name: Stub Cover

Start Date: 4/25/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

Start Time: 1:20
Over Temp: 320 °F
Finish Time: 1:50

2x ~~Ø~~ M-1 11/05/06

Powder Coating

N115128

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/5/06 20

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

37 11/5/06 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Work Order ID 68881

Monday, April 25, 2011 8:38:34 AM



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Item ID: D3494-1

Accept



Setup Start



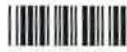
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/99

ME

11-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, April 25, 2011 8:38:31 AM

Page 1

Work Order ID: 68881

Parent Item: D3494-1

Parent Item Name: Stub Cover



Start Date: 4/25/2011


Required Date: 4/29/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-05-18 JLM
IPP rev B ecn 888 06.12.13 EC
add welding DD 10.03.03 verifie by:EC
chg design EC verified by:DD

IPP Rev:C
Ipp RevD ECN 10-555

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	185.5000	0.72	7.578947	10, B114-05		

Location

Loc Qty

Loc Code

MAT020

185.5

117275

185.5

117275



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

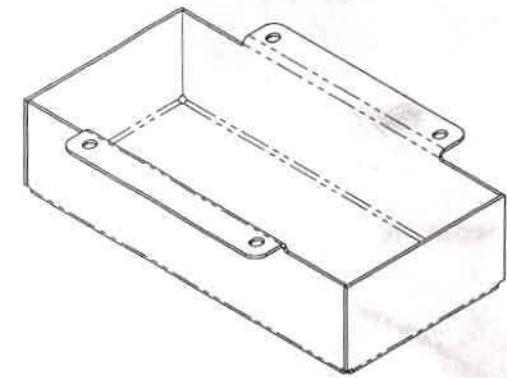
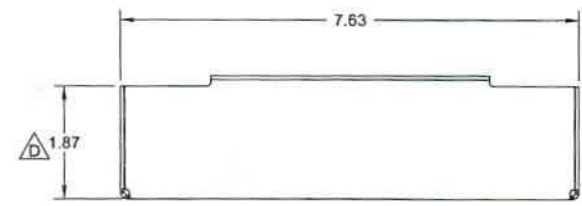
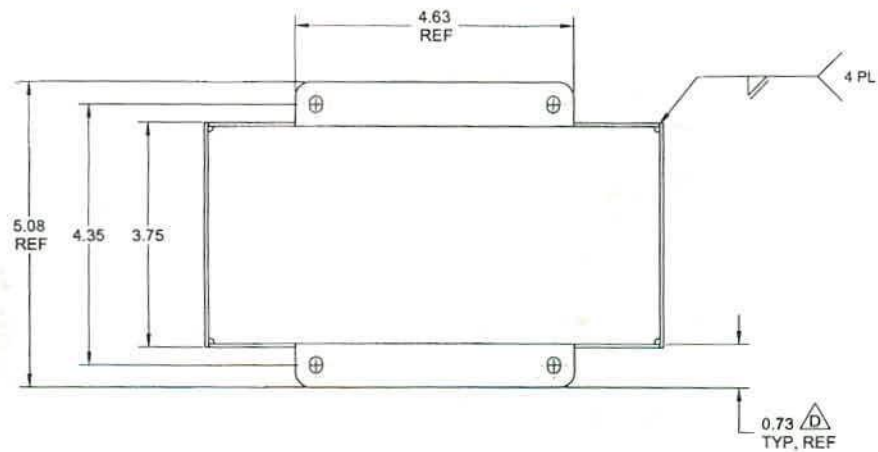
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NOTE: Date & initial all entries

214
4.350
268
4.082



D3494-1 STUB COVER

RELEASED
2010-04-26
AWP

- NOTES:
- 1) MATERIAL: MAKE FROM D3494-1F
 - 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.29 lbs
 - 8) WELD PER DART QSI 004

D	TOLERANCE WAS 3 DEC. PLACES (ZN B5-1); 1.87 WAS 1.86 (ZN B8-1); 2.04 WAS 2.00 (ZN B3-1); REVISED D3494-1F (ZN A8-2); CORRECTED WEIGHT INFO (ZN A8-1); UPDATED MATERIAL (ZN A8-2). REASON: SEE NCR#10-037.	MB	10.04.15
C	DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. C8-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". C5-1 0.87 DIM WAS 0.85. B8-1 1.90 DIM WAS 1.86 B5-1 & 2.04 DIM WAS 2.00. REFER TO PAR 08-003 FOR FURTHER DETAILS.	AJS	08.10.31
B	REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø 0.208 X 0.268 SLOTS WERE Ø 0.208 HOLES.	MB	06.11.28
A	NEW ISSUE	MB	06.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3494	REV. D
TITLE STUB COVER	SCALE NTS
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6888

DART AEROSPACE LTD		Work Order: 68881
Description: STUB COVER		Part Number: D3494-1
Inspection Dwg: D3494-1, Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.208	± .010	.209	✓		V HB02	
.368	± .010	.364	✓		V	
.706	± .010	.768	?		V	
2.528	± .010	2.520	✓		V	
6.278	± .010	6.273	✓		V	
8.039	± .010	8.041	✓		V	
8.437	± .010	8.440	✓		PROW302	
8.805	± .010	8.810	✓		P	
1.832	± .010	1.829	✓		V	
3.262	± .010	3.265	✓		V	
3.604	± .010	3.608	✓		V	
3.940	± .010	3.938	✓		V	
7.544	± .010	7.549	✓		V	
7.887	± .010	7.890	✓		V	
9.317	± .010	9.319	✓		P	
11.148	± .010	11.156	✓		P	
.060	± .010	.057	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:
Date: 11-4-25	Date: 11/04/25	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	